

Work Order ID 84053

84053

Page 1

May 2, 2012 8:17:31 AM

Item ID: D3681-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 5/02/12 Start Qty: 100.00

100

Cust Item ID:

Required Date: 5/07/12 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: *CY*

Date: *12/05/02* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3681	Rev A

100	Hardinge CNC LATHE SMALL	0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA711& DWG D3681 FOLIO REV: <i>DD</i> DWG REV: <i>A</i> 2-DEBURR AS REQUIRED								

111

0

BC
12/05/03

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

111

0

BC
12/05/03

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

SA 12/5/13

111

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item ID: D3681-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 5/02/12 Start Qty: 100.00

100

Cust Item ID:

Required Date: 5/07/12 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.

111 Ø BE 12/05/03

130

Identify as per dwg & Stock Location: LG

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

111 Ø BE 12/05/03

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/05/04
MLJ 12/05/04

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 2, 2012 8:17:30 AM

Page 1

Work Order ID: 84053

Parent Item: D3681-1

Parent Item Name: Spacer

Start Date: 5/02/12

Required Date: 5/07/12

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
 IPP Rev:B Ecn 1056 Rev A dwg DD
 verified by:EC

IPP Rev:C add seq 125 DD 10.05.03

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.058 ALUM TUBE .3125 x .058w		Purchased	No			100	f	149.1860	0.34	35.789474			

56-105103

Location	Loc Qty	Loc Code
MAT013	149.186	
116793	1.667	
116939	19.722	
117400	13.9	
118438	2.584	
119678	86.271	
120654	25.042	

38-85

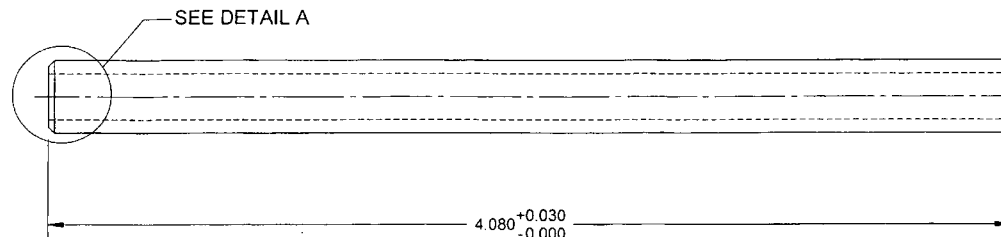
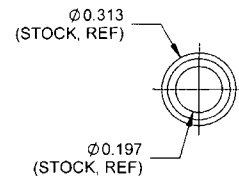
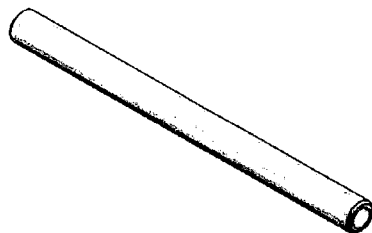
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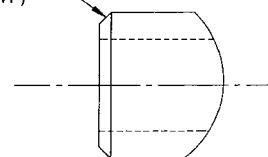
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D3681-1 SPACER

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

0212105102
W/O: 84053

RELEASED
07-11-08

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

REV.	NEW ISSUE	DESCRIPTION	DC	07.11.08
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	BY	DATE
DRAWN	SC			
CHECKED	MD	DRAWING NO.	REV. A	
MFG. APPR.	ED	D3681		SHEET 1 OF 1
APPROVED	W	TITLE	SCALE	
DE APPR.	#	SPACER		2:1
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		

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